

**Work Order ID 70155**

Page 1

Monday, May 30, 2011 12:41:13 PM

Item ID: D500-572-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

IIND500-572

RevA

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

Sulor/22

HGR BG 11-8-18

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/8/1951

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start



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Item Name: Bearpaw

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Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD500-572-011 Location: A

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Suloo/22*



*SP*



*11-08-22 JP*

*11/8/23*

*ME 11-08-23*

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 30, 2011 12:41:21 PM

Page 1

Work Order ID: 70155

Parent Item: D500-572-011

Parent Item Name: Bearpaw



Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM  
 IPP Rev:D 07-01-02 Was K10007 JLM  
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
QS200-M44S 		Purchased	No			120	Each	47.0000	2	816			
Clamp													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST450		47							
				115410		1							
				115589		14							
				<u>116857</u>		12			12				
				117460		20							
AN4-15A 		Purchased	No			170	Each	291.0000	8	3248			
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST308		6							
				116786		6							
				ST357		200							
				<u>117423</u>		200			10				
				ST358		85							
				117794		34							
				117854		51							
AN960JD416 	NAS1149D0463J	Purchased	No			170	Each	0.0000	8	3248			
Washer													
										1118584		11/8/19	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng /- Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, May 30, 2011 12:41:21 PM

Work Order ID: 70155

Parent Item: D500-572-011

Parent Item Name: Bearpaw

Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

170 f

270.9548 1.666 3.664



Rubber Cushion



Location

Loc Qty

Loc Code

ST410

270.95477

66063

270.95477

(D2182B050) cut 4 at 5.00"

D2274

Manufactured No

170 Each

351.0000 8



Radius Block



Location

Loc Qty

Loc Code

ST010

351

59108

12

62658

36

65562

20

67578

44

68937

4

68942

235

D2435

Manufactured No

170 Each

1.0000 2



Bearpaw, 206



Location

Loc Qty

Loc Code

ST497

1

59160

1

D2438

Manufactured No

170 Each

132.0000 4



Clamp



Location

Loc Qty

Loc Code

ST456

132

67830

51

68673

81

Monday, May 30, 2011 12:41:22 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 3

Monday, May 30, 2011 12:41:22 PM

Work Order ID: 70155

Parent Item: D500-572-011

Parent Item Name: Bearpaw

Start Date: 5/30/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2529

Manufactured No

170 Each

399.0000 8



Washer



52 48

Location

Loc Qty

Loc Code

ST016

399

66953

399

MS21042L4

Purchased No

170 Each

4,441.000 8



Nut



48  
32 48  
11/8/19

Location

Loc Qty

Loc Code

ST300

4441

116823

641

117441

3000

117601

800

48

Monday, May 30, 2011 12:41:22 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

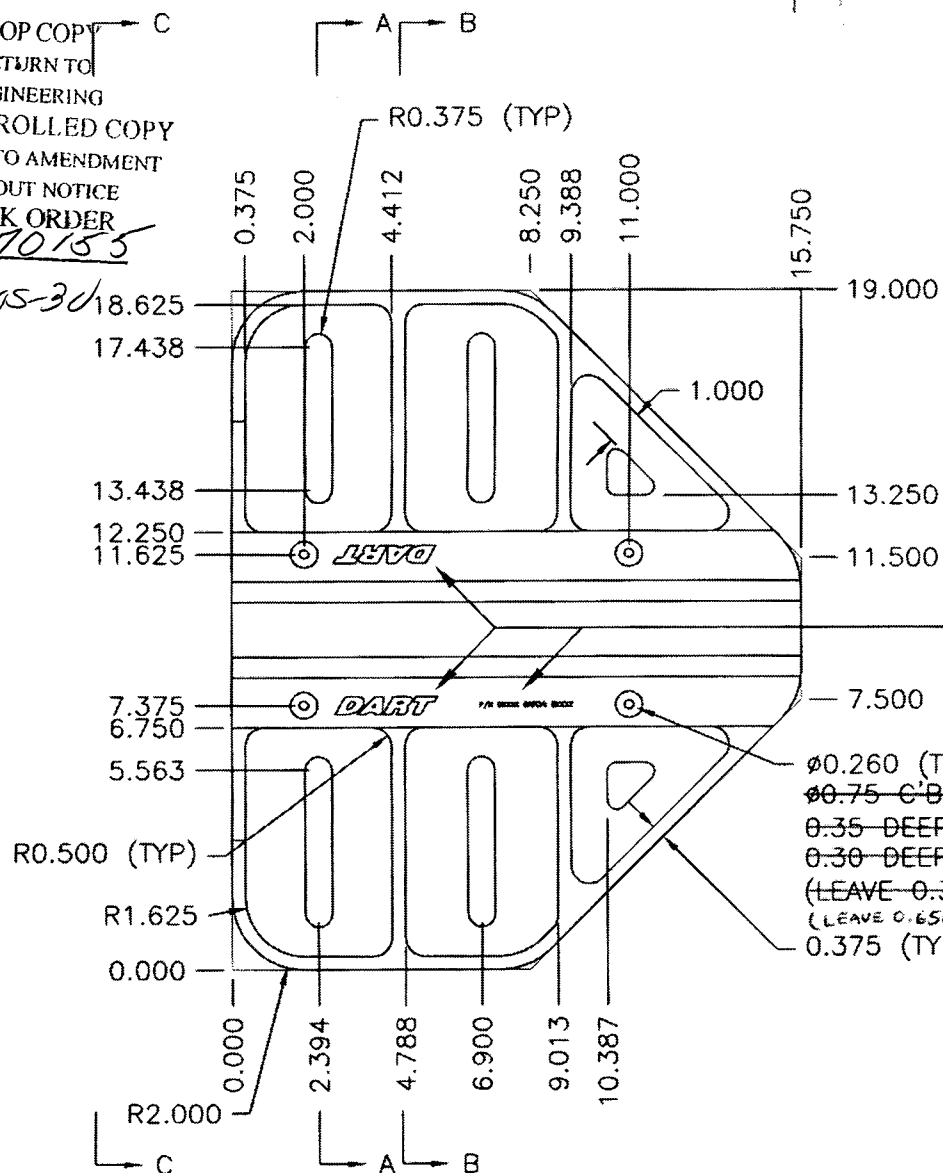
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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2011-05-30 18.6

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ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

E1 02.12.17 00.93 WAS 00.75 ~~RE~~

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

193.06-17 (KE)

**DART**



DESIGN	DATE	CHECKED	APPROVED	DRAWING NO.	REV. E
KE	98.05.19	KE	D2435	SHEET 1 OF 2	
DATE	TITLE	DRAWING NO.			
98.05.19	BEARPAW	D2435			
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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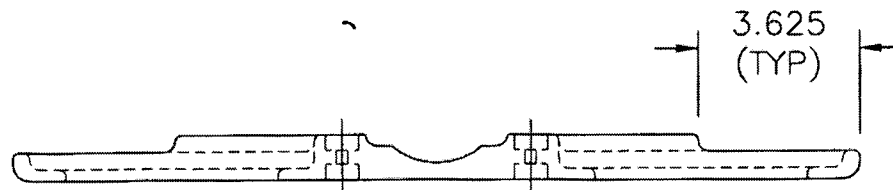
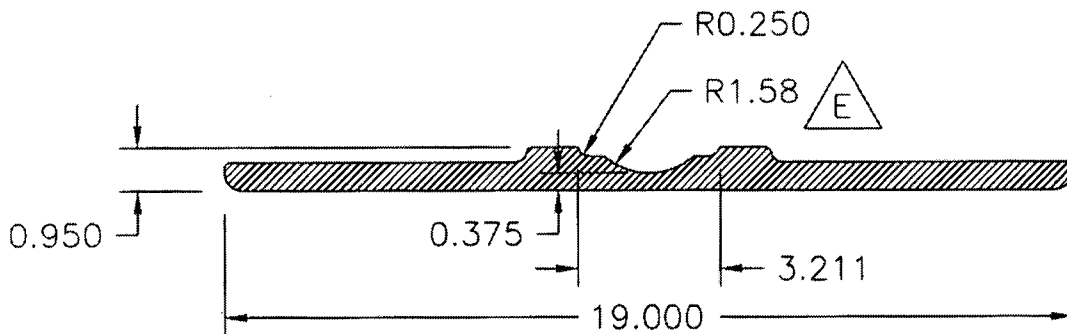
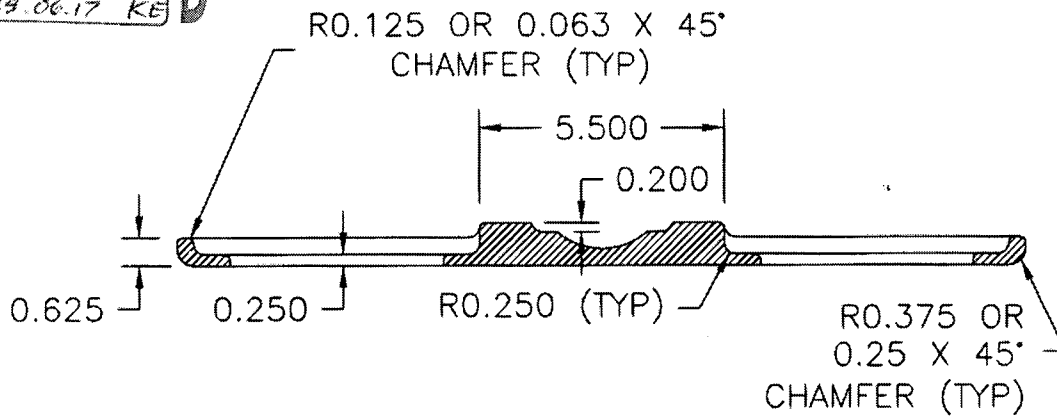
**NOTE:** Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE

*u/o 70155*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**REFERENCE ONLY****32.3 WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

**32.4 PARTS LIST**

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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**32-00-00**